

Ship Aug 18

Page 1

Work Order ID 135300

135300

Tuesday, August 11, 2015 2:05:09 PM

Item ID: D3171-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle Bracket

Start Date: 8/11/2015 Start Qty: 4.00

Required Date: 8/11/2015 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MCS Date: AUG 11 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3171	Rev A
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg D3171 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(6)

08/15/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(6)

08/15/12

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(6)

DAS
38
9-89

AUG 13 2015

Work Order ID 135300***135300***

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Tuesday, August 11, 2015 2:05:09 PM

Item ID: D3171-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle Bracket
Start Date: 8/11/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/11/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00			DAS				
130	Small Fab				30				
Small Fab	Memo	0.00			9-89				N/K
Small Fab	Deburr if necessary								
140		0.00			DAS				
140	NC BRAKE				30				
Brake NC	Memo	0.00			9-89	6			
Brake NC	Bend as per Dwg D3171Tumble								AUG 18 2015
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00				(6)			
Quality Control									DAS 38 9-89 AUG 18 2015

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135300

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Item ID: D3171-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Angle Bracket
 Start Date: 8/11/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>Stop</u>	0.00							
160									
Packaging	Memo	0.00				6			
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.01				ML5			AUG 18 2015
Quality Control									

ML5 AUG 18 2015

Picklist Print

Tuesday, August 11, 2015 2:05:13 PM

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Work Order ID: 135300

135300

Parent Item: D3171-1

D3171-1

Parent Item Name: Angle Bracket

Start Date: 8/11/2015

Required Date: 8/11/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A02.11.04New IssueKJ
IPP Rev:B 08-03-27 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased			No	100	sf	370.8900	0.0206	0.086737			

M304S16GA

304/316 Sheet .063

08/15/08/12

Location

Loc Qty

Loc Code

MAT019

370.89

m131384

60

m131503

54.89

m132797

64

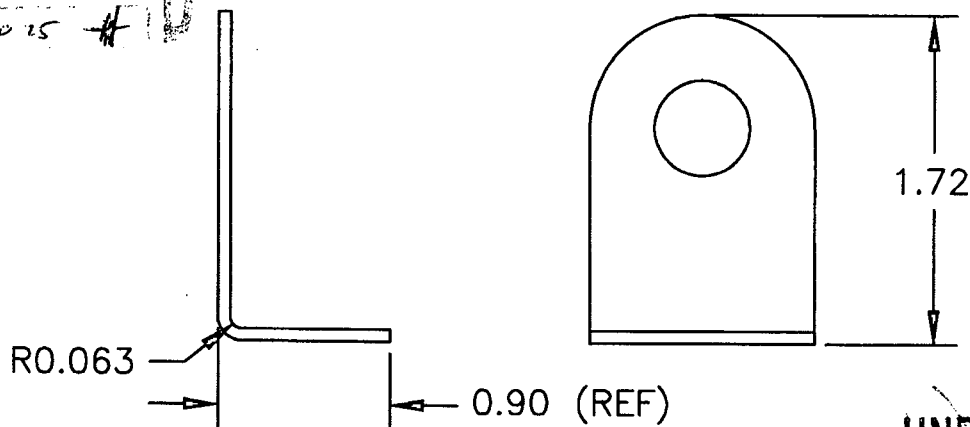
m132835

192



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3171	REV. A SHEET 1 OF 1
DATE 02.10.08		TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	

RELEASED
02.10.25 #



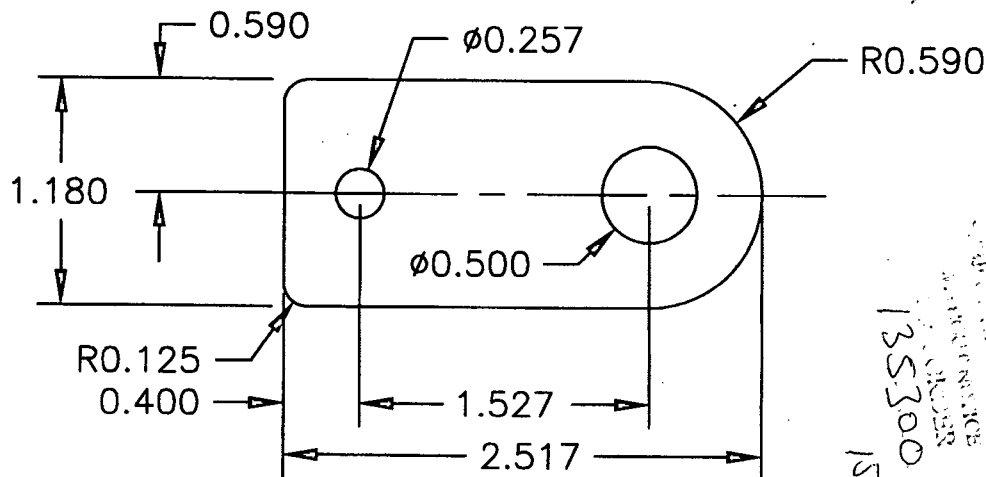
D3171-1 ANGLE

UNDER REVIEW

07.01.02 CB

adding -3

OK
CB
-3 not
being
used



D3171-1 ANGLE FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT TO BE USED
FOR AMENDMENT

135300 MJS
15-08-11

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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